

Date: Thursday, 3/13/2008 10:19:17 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	37924					
Estimate Number	10534					
P.O. Number	:		Part Number	:	D2574	
This Issue	3/13/2008	S.O. No. :	Drawing Number	:	D2574 REV E	
Prsht Rev.	NC		Project Number	:	N/A	
First Issue	/ /	Type : MACHINED PARTS	Drawing Revision	:	E	
Previous Run	37855		Material	:		
Written By	:		Due Date	:	4/4/2008	Qty: 8 Um: Each
Checked & Approved By	:	<i>1080313</i>				
Comment	Est Rev: 1 As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: <i>1334874</i>	<i>SA</i>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <i>5724</i> Double check by <i>LF</i>	<i>5A</i>
	1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	<i>08/03/24</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	<i>SA 08/03/24</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>SA 08/03/24</i>

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 37924

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8F 08/03/25

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1



8

7.0 POWDER COATING POWDER COATING



M107005



8X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l

08/03/26

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



88



8X

Comment: INSPECT POWDER COAT

08-02-26

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STG33

1-83/27 6

10.0 QC21 FINAL INSPECTION/W/O RELEASE



8

Comment: FINAL INSPECTION/W/O RELEASE

108/03/27

Job Completion



mf

08-03-27

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DART AEROSPACE LTD	Work Order:	37924
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.004	8.004		
F	0.490	0.510		.493	.494	.495	.496		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.504	.505	.504	.504		
J	1.174	1.184		1.177	1.179	1.179	1.179		
K	0.558	0.578		.572	.573	.574	.574		
L	1.174	1.184		1.171	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.126	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.257	.257		
S	0.115	0.135		.123	.123	.123	.123		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.241	.243	.241	.241		
W	0.115	0.135		.123	.123	.123	.123		
X	0.307	0.312		.340	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.370	.369	.369	.370		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.629	.629	.628	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.253	.254	.254	.253		
AE	1.500	1.520		1.510	1.512	1.511	1.512		
AF	0.115	0.135		.135	.133	.135	.136		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.252	.253	.253	.254		
AI	2.000	2.020		2.001	2.001	2.001	2.002		
AJ	0.023	0.043		.032	.033	.033	.033		
Accept/Reject									

Measured by: *ST*
Date: *08/03/23*

Audited by: *85*
Date: *08/03/23*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i>	<i>JK</i>

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AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.252	.251	.251	.251		
AI	2.000	2.020		2.002	2.003	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SA
Date: 08/03/24

Audited by: SP
Date: 08/03/24

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